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D350-591-133
Job Sheet 201059



Part No: D350-591-133

Job Qty: 6 pcs

Part Name: AFT Maintenance Step, Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/23/19

Job Tracking No:

Due Date: 11/22/19

Created By: Jennifer Renwick

Type: Stock

Description:

Note: DWG DSI9712 REV A , IIN-D350-591 REV H , D2946 REV.C IPP Rev:B 05.10.14 Modified step 10 KJ/EC IPP Rev:C

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	6 pcs	11/22/19		0.00	6.00	Large Fab - 1		J.R. / S
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
120	QC 5	6 pcs	11/22/19		0.00	0.00	QC 5 - 10		DAS 43 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		

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					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
130	Large Fab - Welded Assy-2-B4B	6 pcs	11/22/19	0.00 9.01	Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	See
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
140	QC 9	6 pcs	11/22/19	0.00 0.00	QC 9 - 10	
					QC 9 - 18	DAS
					QC 9 - 24	24
					QC 9 - 43	9-89
					QC 9 - 50	
					QC 9 - 9	
150	QC 5	6 pcs	11/22/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	DAS
					QC 5 - 24	24
					QC 5 - 3	9-89
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
160	Handfinish - 1-1 Chemical-B4B	6 pcs	11/22/19	0.00 0.91	Handfinish - 1 - 1 - B4B	BEB 19-10-08
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	

					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
170	QC 7	6 pcs	11/22/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	DAS
					QC 7 - 24	81
					QC 7 - 43	9-89
					QC 7 - 61	
					QC 7 - 81	
					QC 7 - 76	
180	Large Fab - Welded Assy-3-B4B	6 pcs	11/22/19	0.00 4.17	Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
190	QC 10	6 pcs	11/22/19	0.00 0.00	QC 10 - 10	
					QC 10 - 18	DAS
					QC 10 - 24	24
					QC 10 - 43	9-89
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OCT 07 2019

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200 QC 5	6 pcs	11/22/19	0.00 0.00	QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	DAS
				QC 5 - 24	24
				QC 5 - 3	9-89
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
210 Handfinish - 1-2- Chemical-B4B	6 pcs	11/22/19	0.00 0.91	Handfinish - 1 - 1 - B4B	BEB/9-10-10.
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
220 Powdercoat - 1 White Gl(A)-B4B	6 pcs	11/22/19	0.00 0.62	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	BR 19-10-11.
230 Handfinish - 3-1- WingWalk-B4B	6 pcs	11/22/19	0.00 0.75	Handfinish - 3 - 1 - B4B	
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
240 QC 3	6 pcs	11/22/19	0.00 0.00	QC 3 - 10	

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					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	OCT 15 2019 DAS 40
					QC 3 - 19	9-89
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
250	Packaging 1-1 - Pick Kit - B4B	6 ✓ pcs	11/22/19	0.00 0.00	Packaging 1 - 1 - B4B	
					Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	
					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	

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OCT 16 2019

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				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
260 QC 4	6 pcs	11/22/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	DAS 78 9-89
					OCT 16 2019
270 Packaging 3-1 - Stock - B4B	6 pcs	11/22/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	DAS 78 9-89
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS 21 9-89
					OCT 16 2019
275 DC - 1 - B4B	6 pcs	11/22/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
280 QC 21 - FG	6 pcs	11/22/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	DAS 21 9-89
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Part Op 110 - (Fabricate per Dwg) 1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946 2- Drill vent hole as per dwg Descriptions: using DT10462 and c'sink.

120 - QC5- Inspect part completeness to step on W/O

130 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Deburr and Bevel ends for welding Use DT8440 jig

140 - (QC9- Inspect visual per QSI004- Fusion Welds)

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Chemical Conversion Coat per QSI005 4.1)

170 - (QC7-Inspect Chemical Conversion Coat)

180 - (Weld per dwg A/R Aluminum rod Batch: _____) 1- Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush. 2- Install rivet in vent hole as per dwg

190 - (QC10- Inspect visual per QSI004- ground welds)

200 - (QC5- Inspect part completeness to step on W/O)

210 - (Chemical Conversion Coat per QSI005 4.1)

220 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____

230 - (Wing Walk as per dwg QSI005 4.4 Batch 5209362)

240 - (QC3- Inspect Part Finish)

250 - (Pick Kit)

260 - (QC4- 100% Inspect kits for completeness)

270 - Identify and pack for shipping as per PPPD350-591-133 Location:FG038

275 - (Document Control) Photocopy bluefile and type labels as per PPP D350-591-133 CHG004

280 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	3 pcs (3 ea)	110-Large Fab - Steps - 1	① 5195347 / "5205619" ✓
D2734	Step End Plate	12 pcs (2 ea)	130-Large Fab - Welded Assy-2- B4B	5195436 ✓
D2944	Step Mounting Plate	12 pcs (2 ea)	130-Large Fab - Welded Assy-2- B4B	5193827 ✓
MS20601-AD4W2	Rivet	6 Ea (1 ea)	180-Large Fab - Welded Assy-3- B4B	5179658(23) S1303 256(1) ✓
AN4-11A	Bolt	24 Ea (4 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5196064(29) S222 097(19) ✓
AN4-16A	Bolt	48 Ea (8 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5107746 ✓
AN4-7A	Bolt	12 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5214343 ✓
D2230-1	Mounting Lug	24 pcs (4 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5187436 ✓
D2230-3	Mounting Lug	24 pcs (4 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5208616(20) S194369(16) S20 7313(16) ✓
D2732-030	Rubber Cushion - 3"	48 pcs (8 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	02 5198489 ✓
D2945	Mounting Plate	6 pcs (1 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5187359 ✓
D3338-1	Mounting Lug	6 pcs (1 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5214467 ✓
MS21042L4	Nut	84 Ea (14 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5192447 ✓
NAS1149D0463J	Washer	84 Ea (14 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D2622-120C	3	87	0
130-Large Fab - Welded Assy-2- B4B	D2734	12	45	0
	D2944	12	17	0
180-Large Fab - Welded Assy-3- B4B	MS20601-AD4W2	6	172	0
250-Packaging 1-1 - Pick Kit - B4B	AN4-11A	24	73	0
	AN4-16A	48	300	0
	AN4-7A	12	69	0
	D2230-1	24	142	0
	D2230-3	24	141	0
	D2732-030	48	310	0
	D2945	6	22	0
	D3338-1	6	22	0
	MS21042L4	84	2,038	0
	NAS1149D0463J	84	3,210	0

Part Specifications

Specifications could not be found.

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5.0 PARTS LIST

Qty -117A	Qty -119	Qty -133	Part Number	Description
X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
	X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
		X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1		D2355	STEP ASSEMBLY (LOW-LONG)
		1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
2	2		D2171	CLAMP
2	2		D2182B035	CUSHION
		4	D2230-1	MOUNTING LUG
		4	D2230-3	MOUNTING LUG
4	4		D2274	RADIUS BLOCK
1			D2362-041	SUPPORT BRACKET
	1		D2362-3	SUPPORT BRACKET
		1	D2945	MOUNTING PLATE
1	1		D3595-200-300	CUSHION
			D2732-030	CUSHION
	2		AN3-37A	BOLT
		2	AN4-7A	BOLT
		4	AN4-11A	BOLT
		8	AN4-16A	BOLT
	4		AN4-21A	BOLT
4	1		AN4-22A	BOLT
	4		NAS1149D0363J	WASHER (AN960JD10)
4	6	14	NAS1149D0463J	WASHER (AN960JD416)
	2		MS21042L3	NUT
4	5		MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
2	2	2	2	D2732-030	CUSHION
2	2	2	2	AN3-37A	BOLT
1	1	1	1	AN4-13A	BOLT
2	2	2	2	AN4-16A	BOLT
4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT